

SECTION A-A

D3785-5 TUBE

PRELIMINARY ISSUE

09.05.12
PER ECN #02-5928

D3785-5 NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM TUBING, 0.375 OD X 0.090 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
(REF. DART SPEC. M6061T6T0.375W.090)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

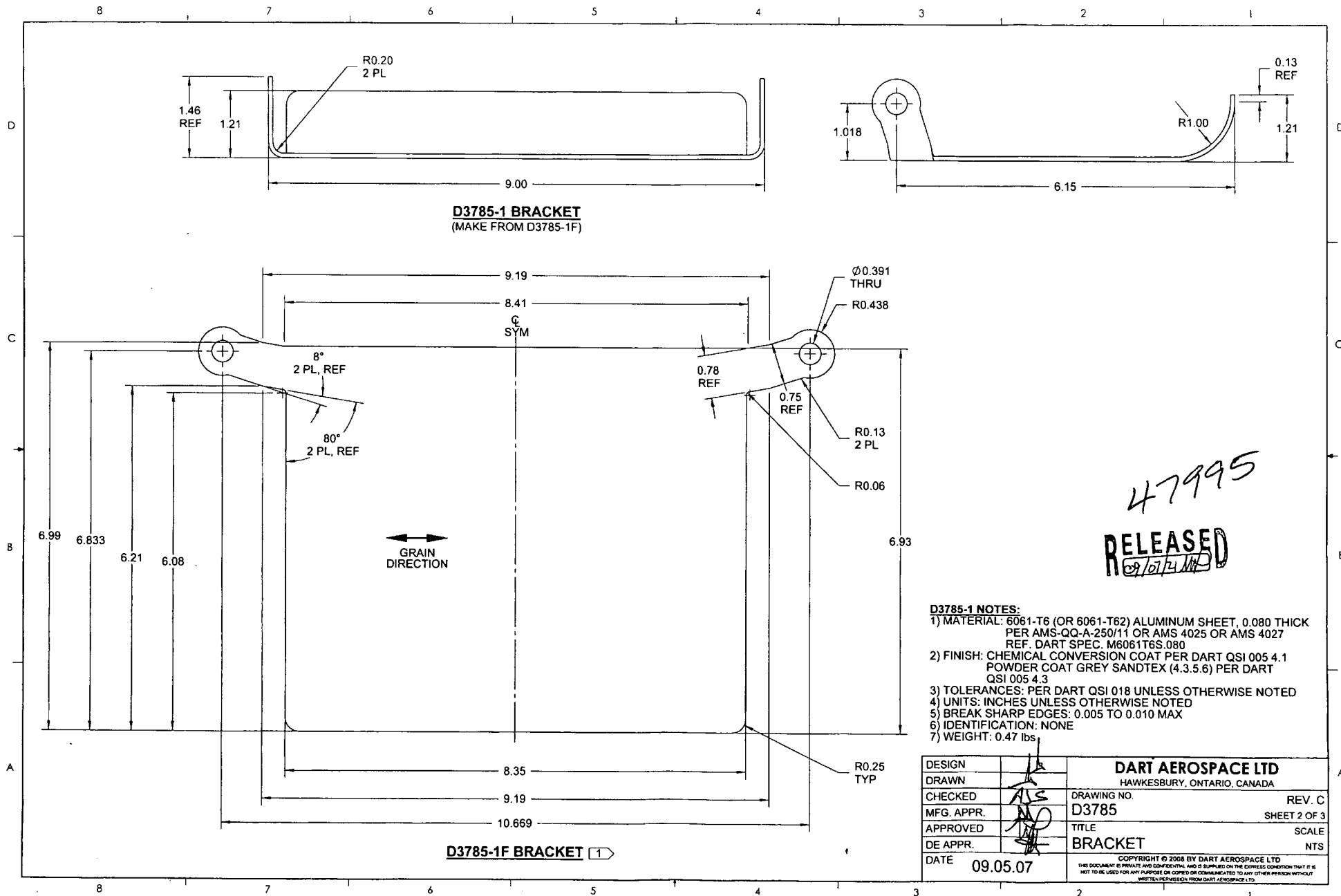
6) IDENTIFICATION: NONE

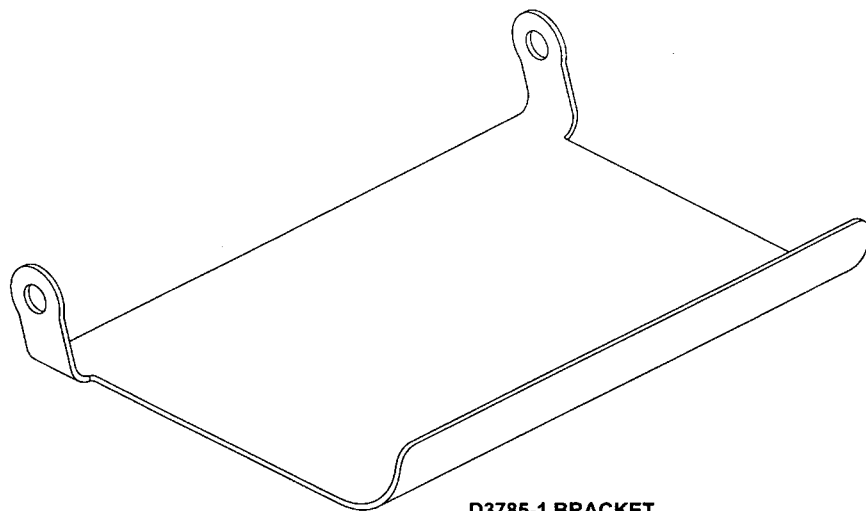
7) WEIGHT: 0.06 lbs

8) DEPTH AT TIP OF DRILL

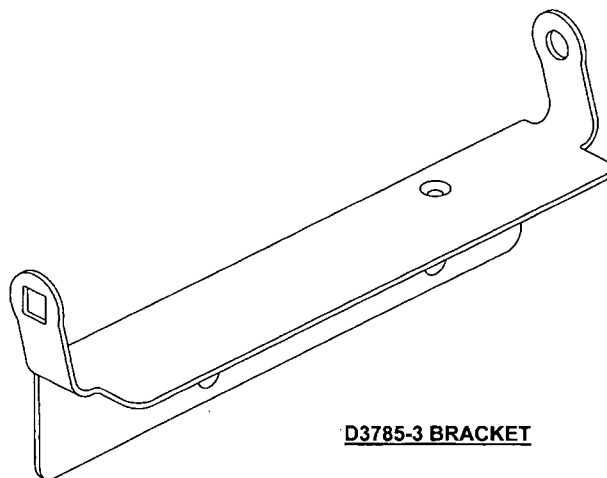
09.05.25
4130 STEEL TUBING PER MIL-T-6736, AMS Q371,
G360, G361, G362, G373 OR G374
REF. DART SPEC. M4130N-T0375W085.

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3785 SHEET 5 OF 5
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
DATE	09.05.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





D3785-1 BRACKET



D3785-3 BRACKET

47995
RELEASED
07/04/11

C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-0411-11-51-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.07		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3785 TITLE BRACKET SCALE NTS REV. C SHEET 1 OF 3 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/05/2009 3:48:02 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FIXTURE
 Job Number : 47995
 Estimate Number : 13295
 P.O. Number :
 This Issue : 19/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 39034
 Written By :
 Checked & Approved By : MF 09-05-19
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC
 Est Rev:B 09-05-15 As per ECN09-593P JLM Verified By:EC

Part Number : D37855
 Drawing Number : D3785 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 26/05/2009 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



09.05.12

Seq. #:	Machine Or Operation:	Description :
1.0	DOOSAN LATHE	DOOSAN LATHE
Comment: Doosan Lathe 1- Turn as per Folio FA Rev: <u>N/A</u> & Dwg D3785 Rev: <u>Prelim</u> 2-Deburr per dwg <u>SA 09/05/25</u>		
2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 09/05/25</u>		
3.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SA 09/05/25</u> <u>09-05-25</u>		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>W/O 48436</u> <u>Armstrong Center 1154</u>		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		<u>09.06.23 082248</u> POSITIVE RECALL EFFECTIVE <u>09.05.26</u> RELEASED AUTH <u>MF 09-06-09</u> DATE

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